

# Work Order ID 55745

January 29, 2010 8:29:09 AM

Page 1

Item ID: D2499

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Bracket, 205 Basket

Start Date: 1/28/10 Start Qty: 10.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-29

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D2499	Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00 *aml 10/01/31*

10 *Ø*

Jeaspa Bandsaw

Cut blanks: 8.500" x 4.000"

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00 *aml 10/02/01*

10 *Ø*

HAAS CNC vertical machine #1

Machine as per folio D2499 Deburr

*87 10/02/03*



120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

*aml 10/02/01*  
*87 10/02/03*

10 *Ø*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2499 PAR #: \_\_\_\_\_ Fault Category: Machined Parts NCR: Yes No DQA: 7 Date: 10-03-07  
 Resolution: Accepted Disposition: Use as is QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>55745</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/03	110.	Dimension of .250 was .002" under tolerance .238".  R.C. operator <del>made the</del> too	<u>CP</u> 10.02.03 PC	Dim @ HOLES is in tol. 0.238 ONLY AT TIP. ACCEPTABLE	<u>L.F.</u> 10/02/03	<u>me</u> 10/02/04	<u>CP</u> 10.02.03 per 05/04	<u>S</u> 10/02/04
		his origin wrong for the first part. R.C. Lack of Attention						

NOTE: Date & initial all entries

# Work Order ID 55745



Page 2

January 29, 2010 8:29:09 AM

Item ID: D2499

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket, 205 Basket

Start Date: 1/28/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Y.A 10/02/04

10 0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10-02-5

0

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

1113170

10-02-08

(X)

9

Powder Coating

\*\*\*\*\*mask slot as per dwg\*\*\*\*\*  
 2:45pm START TIME: 3:15pm FINISH TIME: 3:20F  
 OVEN TEMPERATURE: 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55745**

January 29, 2010 8:29:09 AM

Page 3

Item ID: D2499

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Bracket, 205 Basket

Start Date: 1/28/10 Start Qty: 10.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

BK

10-02-9-

(10)

φ

QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: 513

0.00

Packaging

Memo

0.00

Packaging

P. 10/2/11 (10)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/189

MF  
10-2-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

January 29, 2010 8:29:49 AM

Work Order ID: 55745



Parent Item: D2499

Parent Item Name: Mounting Bracket, 205 Basket

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP A□00.06.26□Removed P/O for powder coat EC  
IPP C Rev C dwg 07-09-25 DD verified by EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			110	f	68.5000	19.9558			



6061-T6 Bar 1.00 x 4.00



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT                                      68.5

107221                                  62.27

→ 11941                                6.23

3.115 *ml* 10/01/31

M8803 0.708'

M6061

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	55745
Description: Mount		Part Number:	D2499
Inspection Dwg: D2499 Rev: C		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.585	+/-0.010	.585	—			
1.252	+/-0.010	1.252	—			
2.085	+/-0.010	2.083	—			
3.585	+/-0.010	3.583	—			
3.960	+/-0.010	3.959	—			
0.375	+/-0.010	.375	—			
0.875	+/-0.010	.877	—			
1.500	+/-0.010	1.503	—			
3.525	+/-0.010	3.528	—			
4.150	+/-0.010	4.147	—			
5.200	+/-0.010	5.200	—			
3.460	+/-0.010	3.460	—			
3.335	+/-0.010	3.335	—			
2.541	+/-0.010	2.541	—			
0.25	+/-0.010	.246	—			
5.700	+/-0.010	5.700	—			
0.115	+/-0.010	.117	—			
0.770	+/-0.010	.764	—			
1.000	+/-0.010	1.000	—			
0.25	+/-0.010	.256	—			
0.38	+/-0.010	.371	—			
0.250	+/-0.010	.240	—			
0.500	+/-0.010	.510	—			
R0.25	+/-0.010	R.250	—			
R0.50	+/-0.010	R.500	—			
R0.38	+/-0.010	R.38	—			
R0.13	+/-0.010	R.130	—			
R0.25	+/-0.010	R.250	—			
R0.06	+/-0.010	R.060	—			
Ø0.257	+0.006/-0.001	Ø.259	—			
Ø0.386	+0.006/-0.001	Ø.385	—			

Measured by:	<i>[Signature]</i>
Date:	10/02/01

Audited by:	H.A
Date:	10/01/04

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

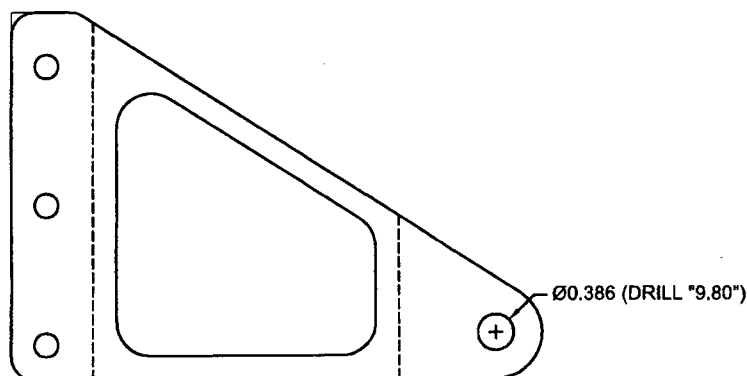
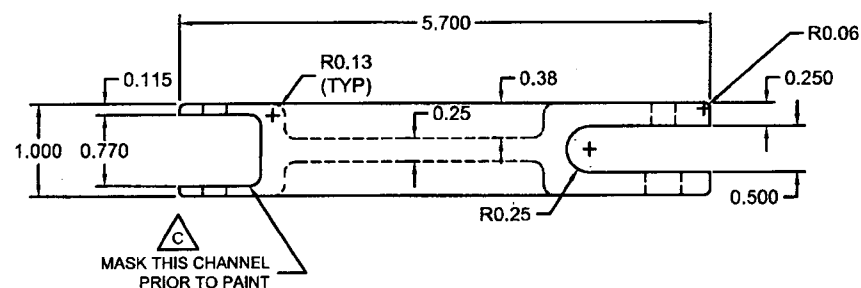
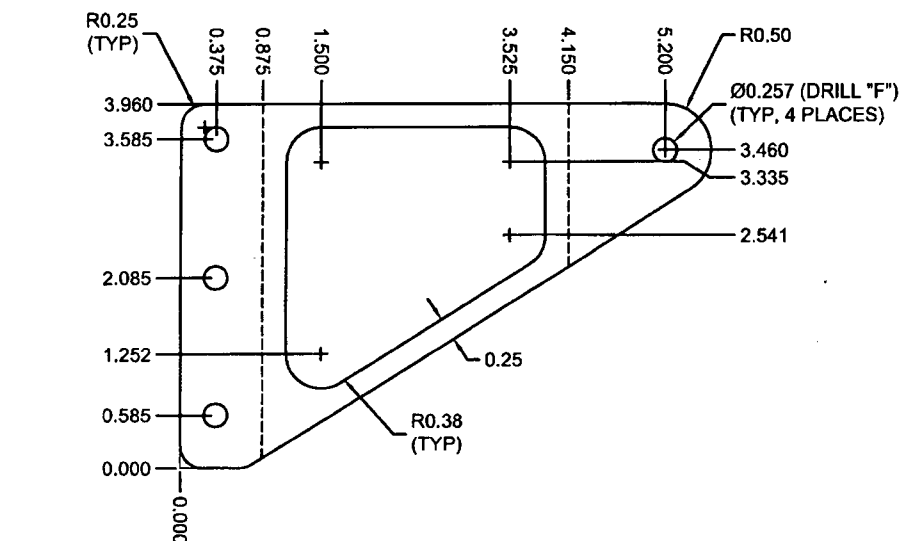
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP  
REWORK  
ENGINEER  
UNCONTROLLED  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
WORK ORDER  
NO. 33745  
07-10-1-29

**RELEASED**

07-08-29

## D2499 MOUNT

### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2499" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.65 lbs

C	- ADDED MASKING DETAIL - DUE TO TIGHT FIT WHEN INSTALLED ON BASKET - ADD MASKING STEP TO ESTIMATE	DC	07.07.25
B	CHANGE HOLE DIA TO .386	KH	95.12.06
A	NEW ISSUE	BW	95.11.09
REV.	DESCRIPTION	BY	DATE

DESIGN	B WILLIAMS	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DC</i>	D2499	SHEET 1 OF 1
APPROVED	<i>DC</i>	TITLE	SCALE
DE APPR.	<i>DC</i>	MOUNT	1:
DATE	07.07.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries